

Date: Tuesday, 12/6/2005 9:24:40 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GHW LUG
Job Number :	25118		
Estimate Number :	11217		
P.O. Number :	N/A	Part Number :	D34041
This Issue :	12/6/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3404 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	B
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	12/23/2005
Written By :	<u>See comment below</u>		Qty: 11
Checked & Approved By :	<u>See comment below</u>		Um: 70 Each
Comment :	Est Rev:A 05.09.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0750X2500	304 BAR .750 X 2.5
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Comment: Qty.: 0.2406 f(s)/Unit Total : 2.4056 f(s)
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick
 (M304B0.750x02.500)
 Identify for D3404-1
 Batch: M7826

En 05/12/12

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 2.750" long

En 05/12/12 11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA555 and Dwg D3404
 Dwg Rev: B Folio Rev: A
 2-Deburr

SA 05.12.13 11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 05.12.13 11

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BG 05.12.14 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GHW LUG

Job Number: 25118

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 423

16 05/12/15

(11)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 05/12/21

(11)

DD 05/12/16

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

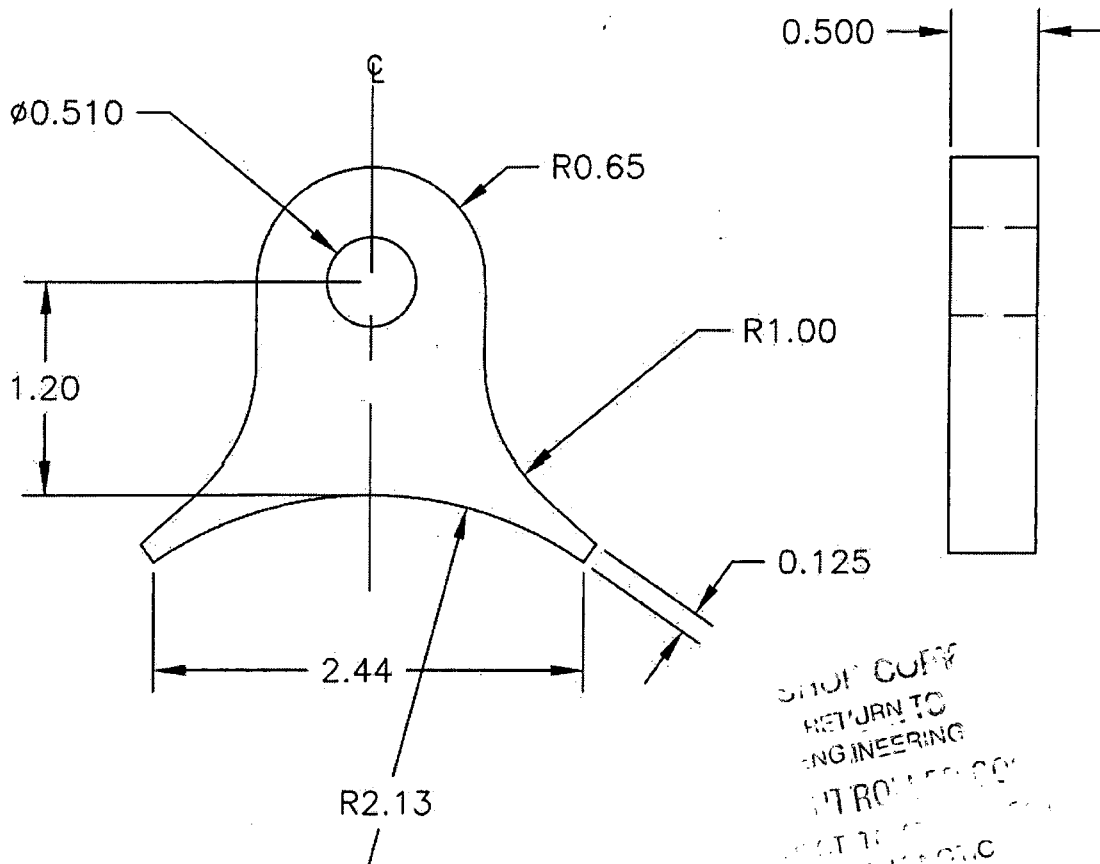
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3404	REV. B SHEET 1 OF 1
DATE 05.06.14		TITLE GHW LUG	SCALE 1:1
A	05.03.08	NEW ISSUE	
B	05.06.14	UPDATE M-SPEC	

RELEASED
05-08-09 *[Signature]***D3404-1****D3404-1 GHW LUG**

- 1) MATERIAL: AISI 304/316 SS BAR
(REF. DART SPEC. M304B0.750X02.500)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP CORNERS 0.03 TO 0.06
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

STOP COPY
RETURN TO
ENGINEERING
CONTROL CO
EST 10
GHW LUG
WORK ORDER
NO. 25118

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